

Work Order ID 61430

Page 1

Wednesday, August 25, 2010 9:11:47 AM

Item ID: D206-667-103TRN

Accept



Setup Start



Revision ID:

Item Name: Crosstube Turning DetailL

Stop



Start Date: 8/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-8-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Memo	0.00	10/08/26	1	0
D206-667-143	Rev C	Memo	0.00			
100		MORI SEIKI CNC LATHE LARGE	0.00			
Mori Seiki		Memo	0.00			
Mori Seiki CNC Lathe Large		1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087 2-Turn first side as per Folio FA087 3-File down transition lines smooth.				
110		QC1- Inspect dimensions to dimension sheet	0.00	10/08/26	1	0
QC		Memo	0.00			
Quality Control						
120		MORI SEIKI CNC LATHE LARGE	0.00	10/08/26	1	0
Mori Seiki		Memo	0.00			
Mori Seiki CNC Lathe Large		1-Turn second side as per Folio FA087 2-File down transition lines smooth. 3-Remove sand and plugs				

W/O:		WORK ORDER CHANGES					
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Stop



Start Date: 8/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

8/25/08/06

1

8

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

(X) MB 10-08-30

150



HandFXtube

Hand Finishing Crosstubes

Crosstubes Chemical Conversion

0.00

DP 10-8-30

Memo

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Required Date: 9/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

(X) Q MB 10-08-30

QC

Quality Control

170



Packaging

0.00

(X) Q MB 10-08-30

Packaging

Packaging

Memo

0.00

Identify and stock in kanban rack Location: x-tube cell

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/08/2010 J

C 10/08/130

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, August 25, 2010 9:11:47 AM

Page 1

Work Order ID: 61430



Parent Item: D206-667-103TRN



Parent Item Name: Crosstube Turning DetailL

Start Date: 8/25/2010

Required Date: 9/8/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed polish EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6002-115		Manufactured	No			110	Each	56.0000	1	1			

Crosstube Material

Location	Loc Qty	Loc Code
LG	56	
34684	1	
34776	55	

mk 10/08/25

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	61430
Description: Crosstube Assembly (206L High Fwd)	Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000 2.249	✓		MIC	8806
	1.982	+0.005/-0.000 1.983	✓		OPEN	AM04
	2.019	+0.005/-0.000 2.021	✓		"	
	2.058	+0.005/-0.000 2.062	✓		"	
	2.097	+0.005/-0.000 2.102	✓		"	
	2.136	+0.005/-0.000 2.139	✓		"	
	2.176	+0.005/-0.000 2.179	✓		"	
	2.201	+0.005/-0.000 2.204	✓		"	
	0.125	+/-0.010 .125			"	
	0.400 x 30°	+/-0.010 400			"	
	R0.063	+/-0.010 .063			"	
	R0.500	+/-0.010 .500			"	
	4.438	+/-0.030 4.430	✓		AM04	
SIDE B	104.98	+/-0.020 104.98	✓		Tape 88-13	
	2.240	+0.005/-0.000 2.245	✓		"	
	1.982	+0.005/-0.000 1.984	✓		"	
	2.019	+0.005/-0.000 2.022	✓		"	
	2.058	+0.005/-0.000 2.064	✓		"	
	2.097	+0.005/-0.000 2.103	✓		"	
	2.136	+0.005/-0.000 2.141	✓		"	
	2.176	+0.005/-0.000 2.180	✓		"	
	2.201	+0.005/-0.000 2.203	✓		"	
	0.125	+/-0.010 .125	✓		"	
	0.400 x 30°	+/-0.010 .400	✓		"	
	R0.063	+/-0.010 .063	✓		"	
	R0.500	+/-0.010 .500	✓		"	
	4.438	+/-0.030 4.440	✓		"	

Measured by:	<i>SP</i>	Audited by:	<i>AB</i>	Prototype Approval:	N/A
Date:	10/08/26	Date:	10-08-30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM <i>JLM</i>	<i>JLM</i>

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8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

Item	Qty	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD).
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

61430

RELEASED
07/11/14

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D206-667-143 REV. C	
CHECKED	97	MFG. APPR. SHEET 1 OF 4	
APPROVED	97	TITLE SCALE CROSSTUBE ASSY (206L HIGH FWD) NTS	
DE APPR.		DATE 08.11.06	
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8 7 6 5 4 3 2 1

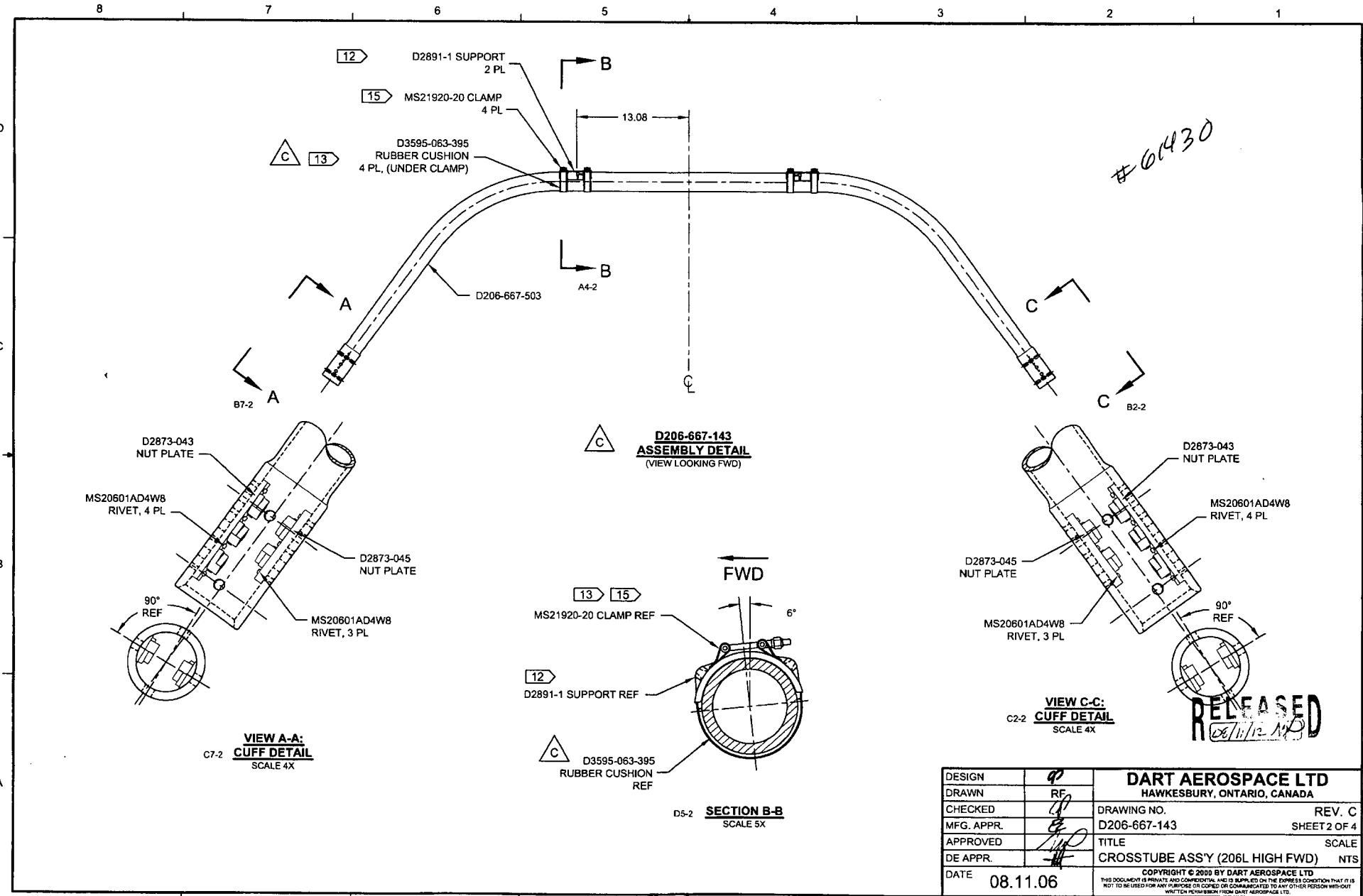
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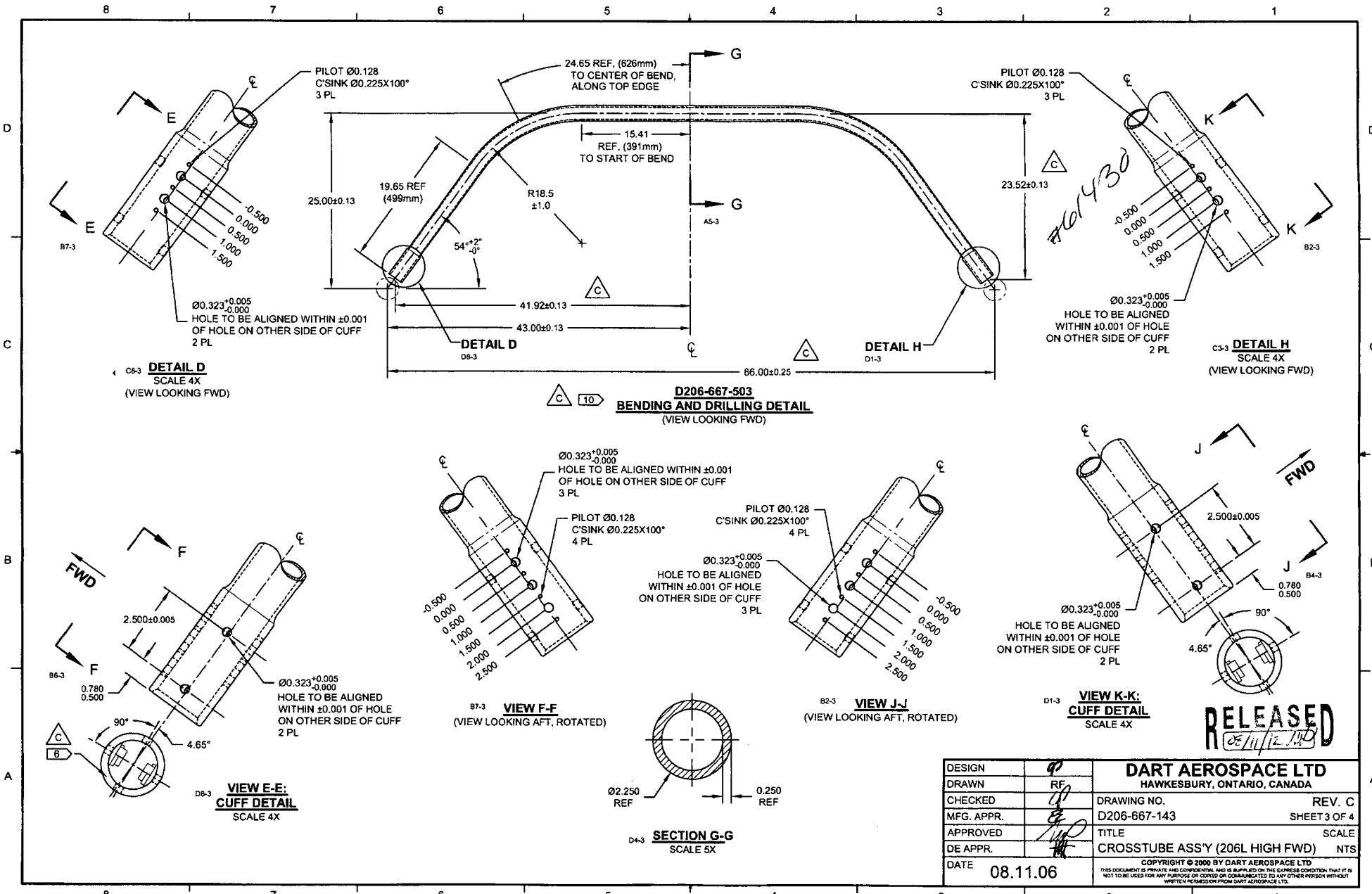
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DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>E</i>	D206-667-143	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
OE APPR.	<i>[Signature]</i>	CROSSTUBE ASSY (206L HIGH FWD) NTS	
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION OWNED BY DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

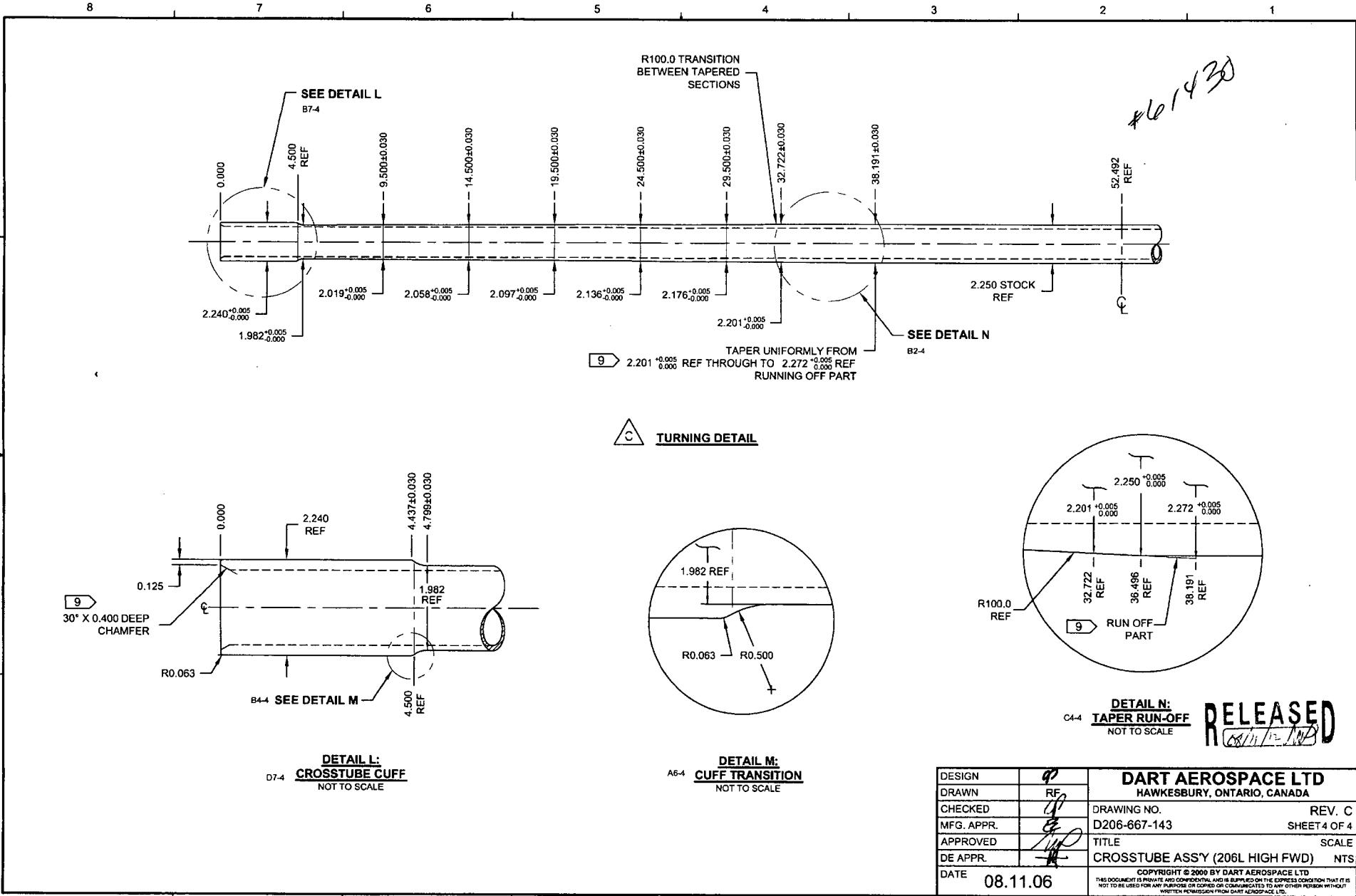
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